

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013679**Date Inspected:** 06-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY 10

This QA Inspector observed the following work in progress:

Sub-Merged Arc Welding (SAW):

Weld joint # 13A located on Grillage Plate SSD1 – TL5 – 1B – F. Welder is identified as 209051. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Zai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3221 – B – U3c – S – 1. (See attached Photo)

Weld joint # 6B located on Grillage Plate NSD1 – TL5 – 3B – F. Welder is identified as 207745. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Zai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3221 – B – U3c – S – 1.

Shielded Metal Arc Welding (SMAW):

Repair welding of a weld joint # 1B according to the Critical weld repair report #T-CWR-533 located on North Tower Lift-4 C/D corner. Welder is identified as 057258. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS –345– SMAW – 1G (1F) – Repair.

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Repair welding of a weld joint # 5B according to the Critical weld repair report #T-CWR-591 located on North Tower Lift-4 B/C corner. Welder is identified as 052930. ZPMC Quality Control (QC) Inspector is identified as Gong Liang Zhu. The welding variables recorded by QC appeared to comply with the WPS –345– SMAW – 2G (2F) – Repair.

BAY 11

This QA Inspector observed the following work in progress:

Sub-Merged Arc Welding (SAW):

Weld joint # 1-3A located on Strut Plate WD1 – STSA4 – 5 – 131. Welder is identified as 047304. ZPMC Quality Control (QC) Inspector is identified as Lijun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4221 – B – U3c – S – 1.

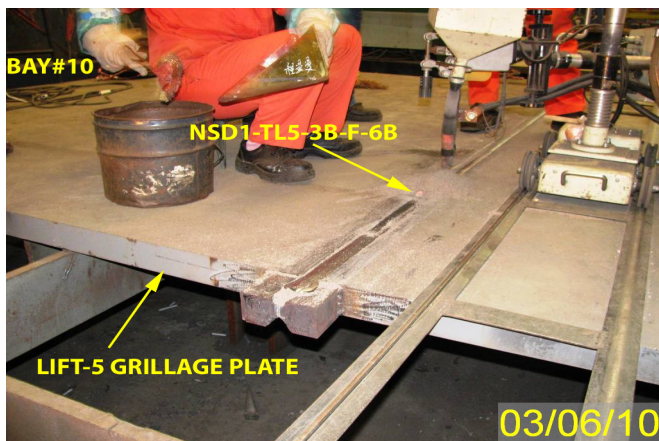
Weld joint # 1-3A located on Strut Plate WD1 – STSA4 – 5 – 127. Welder is identified as 041716. ZPMC Quality Control (QC) Inspector is identified as Lijun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4221 – B – U3c – S – 1.

Shielded Metal Arc Welding (SMAW):

Weld joint # 20B located on West Tower Lift-5 A/B corner WSD1 – TL5 – 4B – F. Welder is identified as 049099. ZPMC Quality Control (QC) Inspector is identified as Shao Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 – Tc – U4b – 1.

Weld joint # 32B located on West Tower Lift-5 A/B corner WSD1 – TL5 – 4B – F. Welder is identified as 040656. ZPMC Quality Control (QC) Inspector is identified as Shao Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3212 – Tc – U4b – 1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

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No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest - 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Sandeep
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Quality Assurance Inspector

Reviewed By:	Clifford,William
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QA Reviewer
